



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

split

654.2801
Job Sheet 206823-A



Part No: 654.2801

Job Qty: 10 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/20

Job Tracking No:

Due Date: 2/28/20

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG 654.2800 Rev.N/C IPP Rev. A 19.11.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
130	QC 8	10 pcs	2/28/20		0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
135	Small Fab - Brake NC - B4B	10 pcs	2/28/20		0.00	1.67	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		



Dart Aerospace Ltd.
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CANADA
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Container No: S258529



Part: 654.2801

Job No: 206823-A

Serial No/Batch: S255589

Revision: N/C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/26/20

2020 FEB 26

					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
					Small Fab - Various 1 - B4B	
140	QC 5	10 pcs	2/28/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	DAS 40 9-89
					QC 5 - 50	
					QC 5 - 30	DAS 32 9-89
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
150	Small Fab - 2 - B4B	10 pcs	2/28/20	0.00 1.00	Small Fab - 1 - B4B	DAS FEB 27 2020
					Small Fab - 2 - B4B	58 9-89
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
					Small Fab - Various 1 - B4B	
160	QC 5	10 pcs	2/28/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
210	Spray Paint - 2 - B4B	10 pcs	2/28/20	0.00 1.00	Spray Paint - 1 - B4B	BEB 20-02-28
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	

DAS 10 9-89 2020-02-28

162 Chemical Conversion
hand FINISH 1-3 BRB FEB 28 2020

165 QC 7 FEB 20-02-28
DAS 59 9-89

166 powder coat
Fire red

220 QC 14 200 QC3 h	10 pcs	2/28/20	0.00 0.00	Spray Paint - 4 - B4B	
				QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
				QC 14 - 82	
					DA 8 9-8
					FEB 28 2020
230 Packaging 3-1 - Stock - B4B	10 pcs	2/28/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
					DAS 19 9-00
240 QC 21 - SA	10 pcs	2/28/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 130 - (QC8- Inspect parts - second check) Descriptions: 135 - (Small Fab) 1-Form as per drawing					FEB 28 2020

Plex 2/26/20 8:07 AM dart.lacelle.linda

140 - (QC5- Inspect part completeness to step on W/O)

150 - Assemble as per drawing.

160 - (QC5- Inspect part completeness to step on W/O)

210 - 1-PRETREAT CARDINAL 4860-4702 ACID ETCH WASH PRIMER (GRAY) As per MPP-172 SECTION 3.3 PRIME:

Batch #: _____ Start Time: _____ Finish Time: _____ 2-PRIMER CARDINAL 7760-4702 LOW VOC

EPOXY PRIMER (LIGHT GRAY) As per MPP-172 SECTION 4.3 Batch #: _____ Start Time: _____ Finish Time: _____

3-Spray paint RED: POLYURETHANE PAINT CARDINAL 6409-RDO3-S WITH CATALYST 340HP As per

MPP-172 SECTION 5.3 Batch #: _____ Start Time: _____ Finish Time: _____

220 - (QC14- Inspect Spray Paint)

230 - (Identify as per dwg & Stock Location: FK DALK)

240 - (QC21- Final Inspection - Work Order Release)

5225472 Powder Coat START: 10:25 TEMP: 320° FINISH: 10:55

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CR3213-4-3	Rivet, Cherry	40 Ea (4 ea)	150-Small Fab - 2 - B4B	5228(6)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
150-Small Fab - 2 - B4B	CR3213-4-3	40	571	0

Part Specifications

Specifications could not be found.

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654.2801

Job Sheet 206823



Part No: 654.2801

Job Qty: 20 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/12/20

Job Tracking No:

Due Date: 2/26/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 654.2800 Rev.N/C IPP Rev. A 19.11.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	20 pcs			0.17	4.00	Waterjet - Flow		OK 20/02/13 TF
120	QC 2	20 pcs			0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		OK 20/02/13 TF
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

Plex 2/12/20 9:21 AM Dart.lajeunesse.marie

130 QC 8	20 pcs	0.00 0.00	QC 2 - 5	
			QC 2 - 71	
			QC 2 - 73	
			QC 2 - 69	
			QC 2 - 76	
			QC 8 - 12	
			QC 8 - 14	
			QC 8 - 17	
			QC 8 - 20	
			QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
135 Small Fab - Brake NC - B4B 20 pcs		0.00 3.33	Small Fab - 1 - B4B	
			Small Fab - 2 - B4B	
			Small Fab - 3 - B4B	
			Small Fab - 4 - B4B	
			Small Fab - 5 - B4B	
			Small Fab - 6 - B4B	
			Small Fab - 7 - B4B	
			Small Fab - 8 - B4B	
			Small Fab - 9 - B4B	
			Small Fab - Various 1 - B4B	
140 QC 5	20 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	

FFR 13 2020

DAS
40
9-89

150 Small Fab - 2 - B4B	20 pcs	0.00 2.00	QC 5 - 61	
			QC 5 - 81	
			Small Fab - 1 - B4B	
			Small Fab - 2 - B4B	
			Small Fab - 3 - B4B	
			Small Fab - 4 - B4B	
			Small Fab - 5 - B4B	
			Small Fab - 6 - B4B	
			Small Fab - 7 - B4B	
			Small Fab - 8 - B4B	
			Small Fab - 9 - B4B	
160 QC 5	20 pcs	0.00 0.00	Small Fab - Various 1 - B4B	
			QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
210 Spray Paint - 2 - B4B	20 pcs	0.00 2.00	Spray Paint - 1 - B4B	
			Spray Paint - 2 - B4B	
			Spray Paint - 3 - B4B	
			Spray Paint - 4 - B4B	
220 QC 14	20 pcs	0.00 0.00	QC 14 - 15	
			QC 14 - 2	
			QC 14 - 34	
			QC 14 - 41	
			QC 14 - 51	
			QC 14 - 58	
			QC 14 - 59	
			QC 14 - 9	
			QC 14 - 68	
			QC 14 - 40	
			QC 14 - 19	
			QC 14 - 43	
			QC 14 - 24	
			QC 14 - 61	
			QC 14 - 81	
			QC 14 - 82	
230 Packaging 3-1 - Stock - B4B	20 pcs	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	

			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
240 QC 21 - SA	20 pcs	0.00 0.00	QC 21 - SA - 21	
			QC 21 - SA - 70	
			QC 21 - SA - 53	

Part Op 110 - 1-Cut as per Dwg Dwg Rev: N/C Prog Rev: N/C 2-Debur.
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 135 - (Small Fab) 1-Form as per drawing
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - Assemble as per drawing.
 160 - (QC5- Inspect part completeness to step on W/O)
 210 - 1-PRETREAT CARDINAL 4860-4702 ACID ETCH WASH PRIMER (GRAY) As per MPP-172 SECTION 3.3 PRIME:
 Batch #: _____ Start Time: _____ Finish Time: _____ 2-PRIMER CARDINAL 7760-4702 LOW VOC
 EPOXY PRIMER (LIGHT GRAY) As per MPP-172 SECTION 4.3 Batch #: _____ Start Time: _____ Finish Time: _____
 3-Spray paint RED: POLYURETHANE PAINT CARDINAL 6409-RDO3-S WITH CATALYST 340HP As per
 MPP-172 SECTION 5.3 Batch #: _____ Start Time: _____ Finish Time: _____
 220 - (QC14- Inspect Spray Paint)
 230 - (Identify as per dwg & Stock Location: _____)
 240 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	6.8000 sf (.34 ea)	110-Waterjet - Flow - 1	5252605
CR3213-4-3	Rivet, Cherry	80 Ea (4 ea)	135-Small Fab - Brake NC - B4B	
CR3213-4-3	Rivet, Cherry	80 Ea (4 ea)	150-Small Fab - 2 - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M2024T3S.063	7	171	0
135-Small Fab - Brake NC - B4B	CR3213-4-3	80	621	0
150-Small Fab - 2 - B4B	CR3213-4-3	80	621	0

Part Specifications

Specifications could not be found.

Plex 2/12/20 9:21 AM Dart.lajeunesse.marie

INSPECTION SHEET

**DAS
40
9-89**

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation				Disposition	
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			